

Date: Thursday, 10/18/2007 7:58:58 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BAFFLE & DEFLECTOR ASSEMBLY
Job Number	: 35190		
Estimate Number	: 12223		
P.O. Number	: <u>N/A</u>	Part Number	: D3467049
This Issue	: 10/18/2007 S.O. No. : <u>NA</u>	Drawing Number	: D3467 REV B <i>OK for rev B 10/18</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>NA</u> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 34490	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 10/24/2007
Checked & Approved By	: <u>[Signature]</u> 07.10.18	Qty:	4 Um: Each
Comment	: Est Rev. A New Issue 06-04-24 JLM Est Rev.B As per Rev B 06-05-24 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D346715	DEFLECTOR
-----	---------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3467-15	Deflector	<u>B35216</u>

MF 07-11-28

2.0	D346713	BAFFLE
-----	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-13	Baffle	<u>B34107 x 3mx, B35215 x 3mx MF 07-11-28</u>

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467

2-Spot Weld as per Dwg D3467 and Dart QSI 004

MF 07-11-28

(4)

4.0	QC11	VISUAL INSPECTION OF SPOT WELDING
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Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/11/29 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 02/11/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 7:58:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE & DEFLECTOR ASSEMBLY

Job Number: 35190

Part Number: D3467049

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8B 07/11/29

(4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57159

07/14/29

(4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/29

(4)

Job Completion



07/16/29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

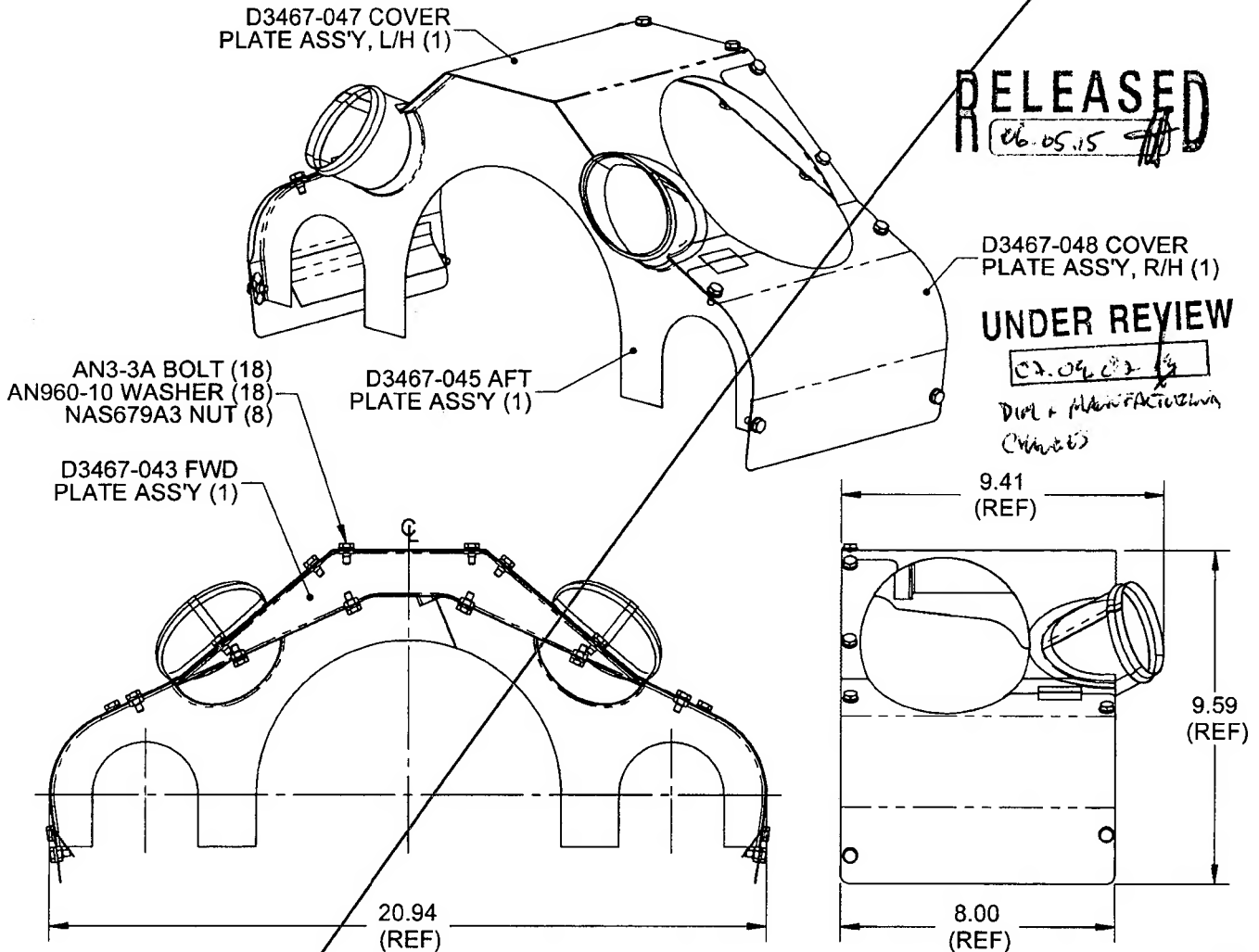
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3467	REV. B SHEET 1 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:5
A	05.12.07	NEW ISSUE	
B	06.05.15	Ø0.250 & Ø0.203 WERE Ø0.194 ; UPDATED D3467-9F/-15F	



D3467-041 SHROUD ASSEMBLY

NOTES:

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

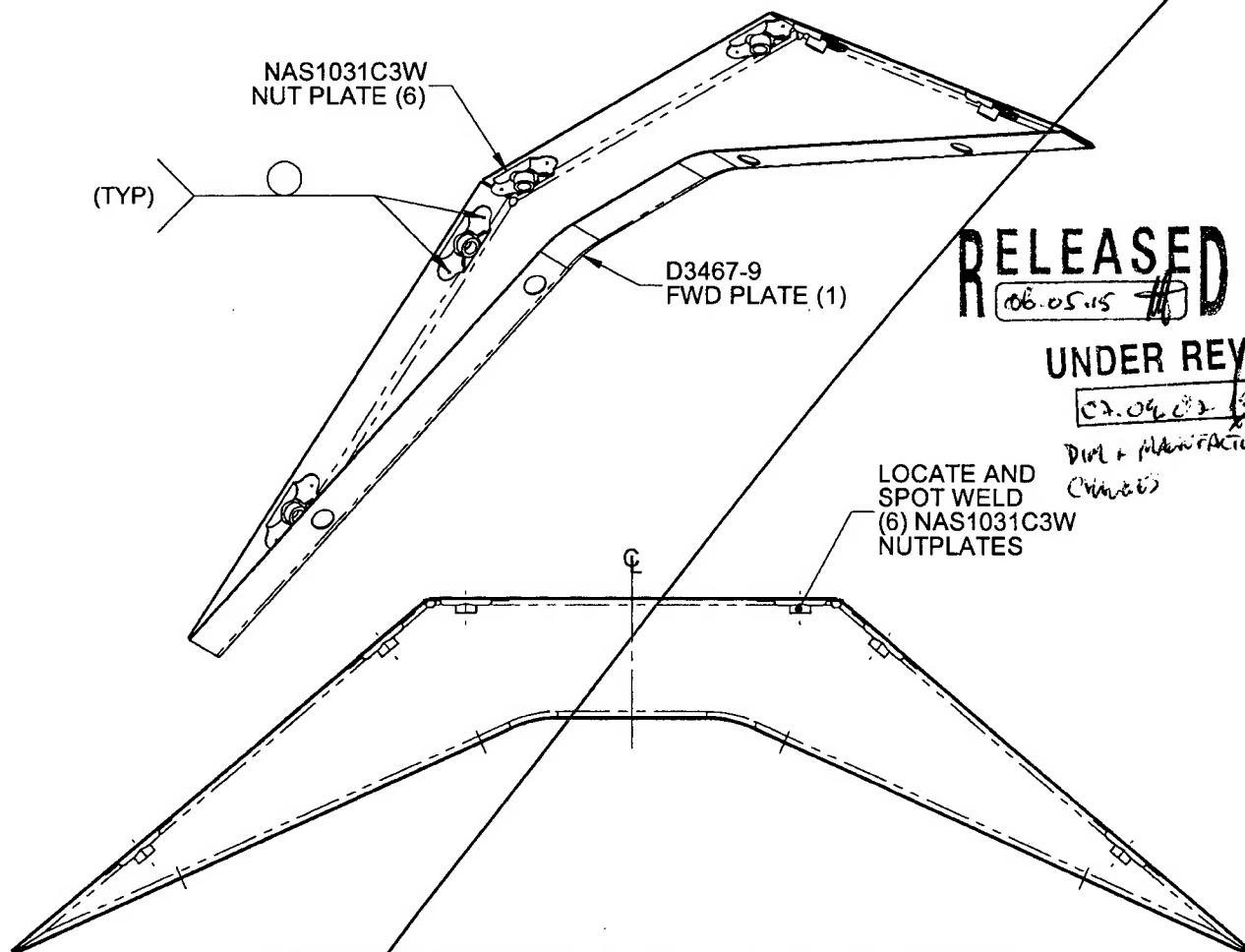
QTY -041	P/N	DESCRIPTION
X	D3467-041	SHROUD ASSEMBLY
1	D3467-043	FWD PLATE ASSEMBLY
1	D3467-045	AFT PLATE ASSEMBLY
1	D3467-047	COVER PLATE ASSEMBLY, L/H
1	D3467-048	COVER PLATE ASSEMBLY, R/H
18	AN3-3A	BOLT
18	AN960-10	WASHER
8	NAS679A3	NUT

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CHECKED 13	APPROVED 13	DRAWING NO. D3467	REV. B SHEET 2 OF 15
DATE 06.05.15	TITLE SHROUD ASSEMBLY		SCALE 1:2



QTY -043	P/N	DESCRIPTION
X	D3467-043	FWD PLATE ASSEMBLY
1	D3467-9	FWD PLATE
6	NAS1031C3W	NUT PLATE

D3467-043 FWD PLATE ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

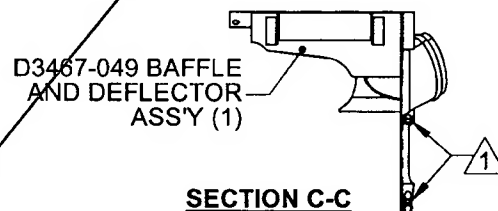
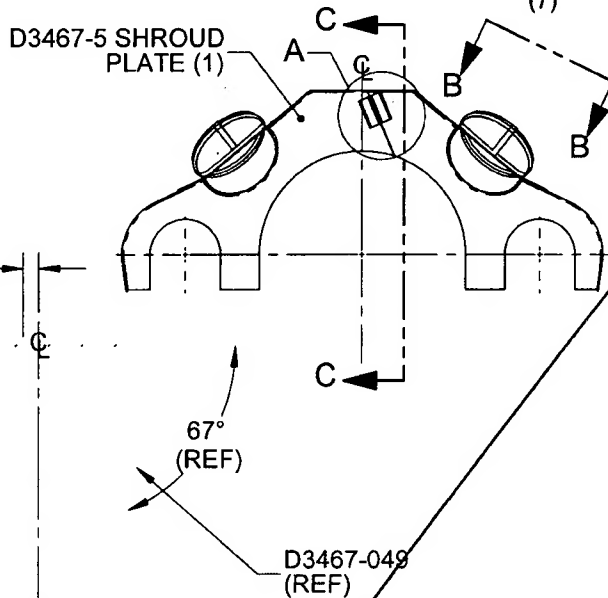
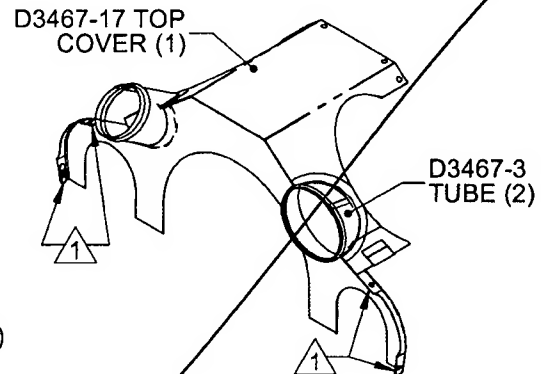
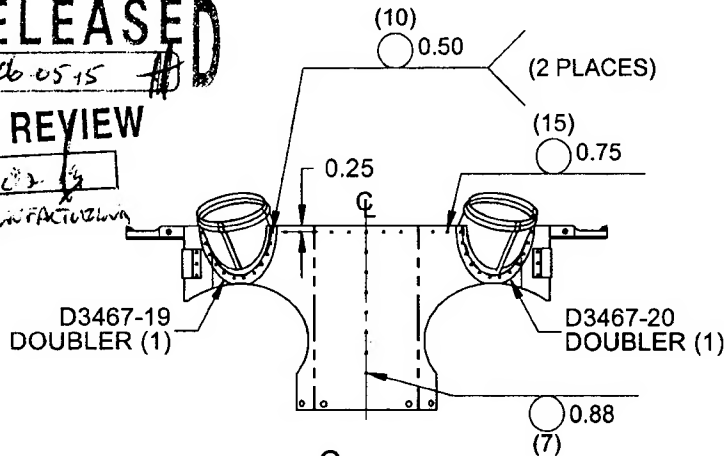
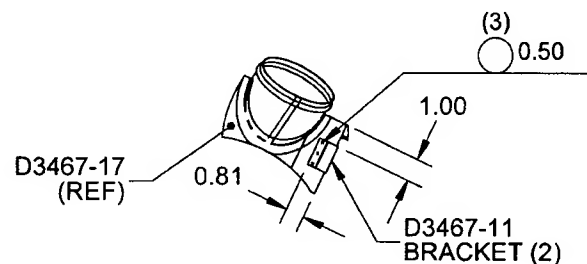
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DATE 06.05.15	TITLE SHROUD ASSEMBLY		SCALE 1:8

RELEASED
06-05-15**UNDER REVIEW**DIP + MANUFACTURING
CHECKS**SECTION C-C****VIEW B-B: WELDING D3467-11**
D3467-047 NOT SHOWN FOR CLARITY
(2 PLACES)**DETAIL A**
SCALE 1:2**D3467-045 AFT PLATE ASSEMBLY****NOTES:**

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -045	P/N	DESCRIPTION
X	D3467-045	AFT PLATE ASSEMBLY
1	D3467-049	BAFFLE AND DEFLECTOR ASSEMBLY
2	D3467-3	TUBE
1	D3467-5	SHROUD PLATE
2	D3467-11	BRACKET
1	D3467-17	TOP COVER
1	D3467-19	DOUBLER
1	D3467-20	DOUBLER
4	NAS1031C3W	NUT PLATE

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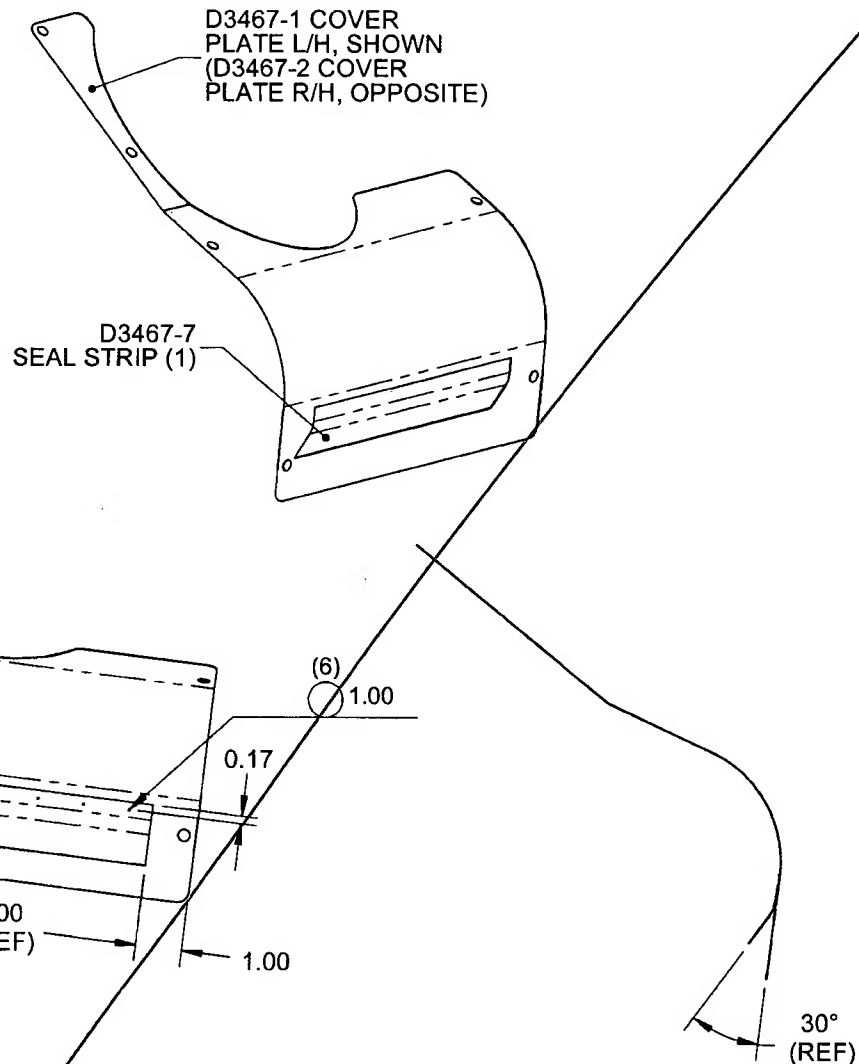


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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

RELEASED
06.05.15

UNDER REVIEW

02.04.15
DIP + MANUFACTURING
CHECKED



D3467-047 COVER PLATE ASS'Y L/H, SHOWN
D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -047	QTY -048	P/N	DESCRIPTION
X		D3467-047	COVER PLATE ASSEMBLY, L/H
	X	D3467-048	COVER PLATE ASSEMBLY, R/H
1		D3467-1	COVER PLATE, L/H
	1	D3467-2	COVER PLATE, R/H
1	1	D3467-7	SEAL STRIP

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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

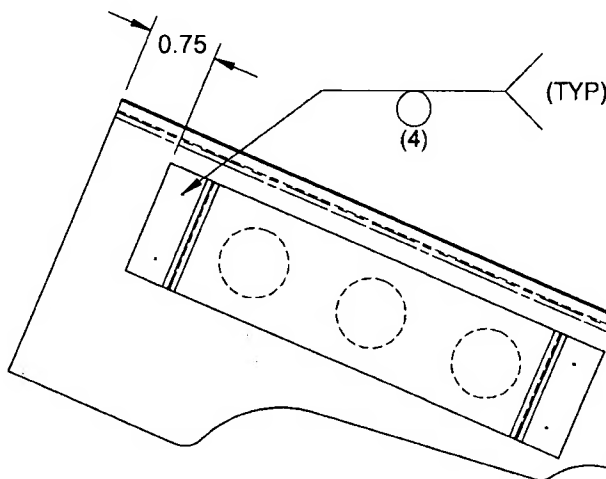
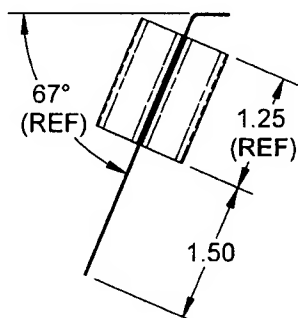
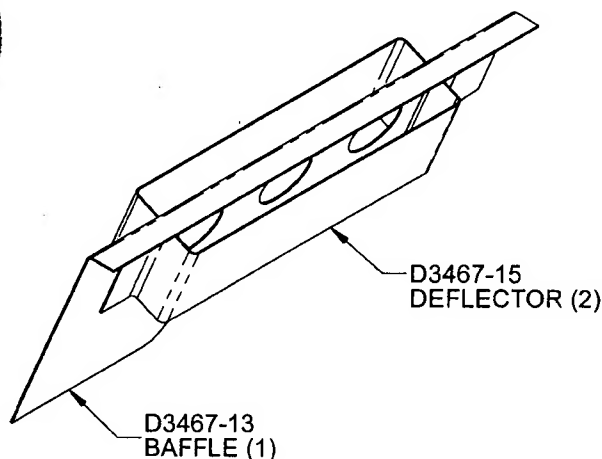
RELEASED
06.05.15**UNDER REVIEW**

02.08.15

DIPLOMANA
CHIEF

OK

07.10.18

**D3467-049 BAFFLE & DEFLECTOR ASSEMBLY**

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NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

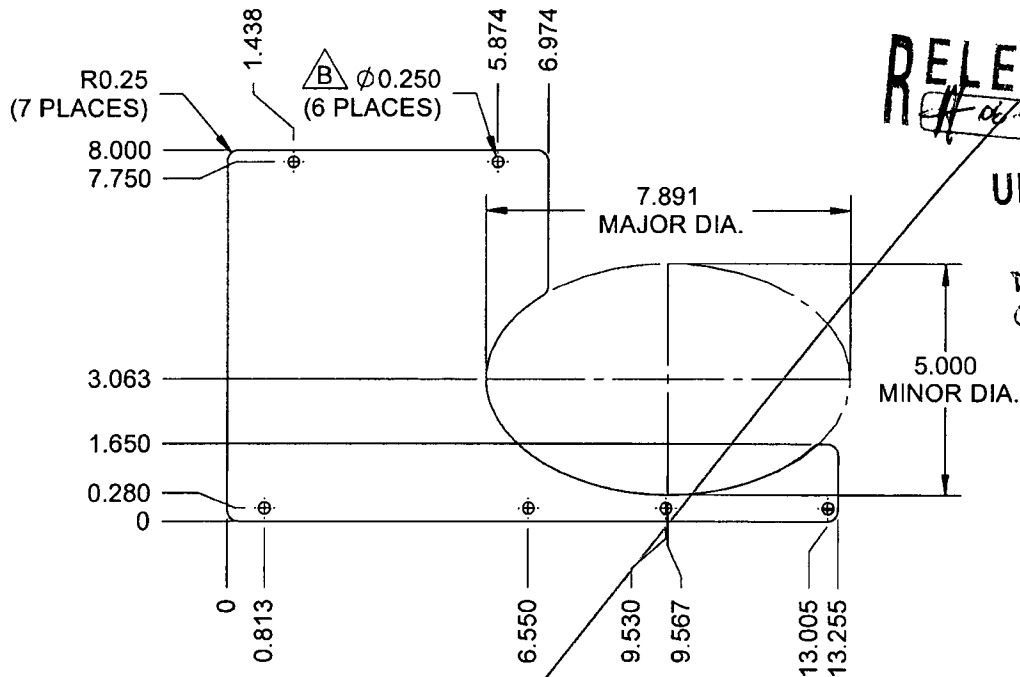
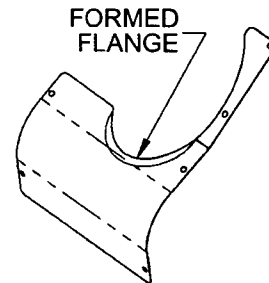
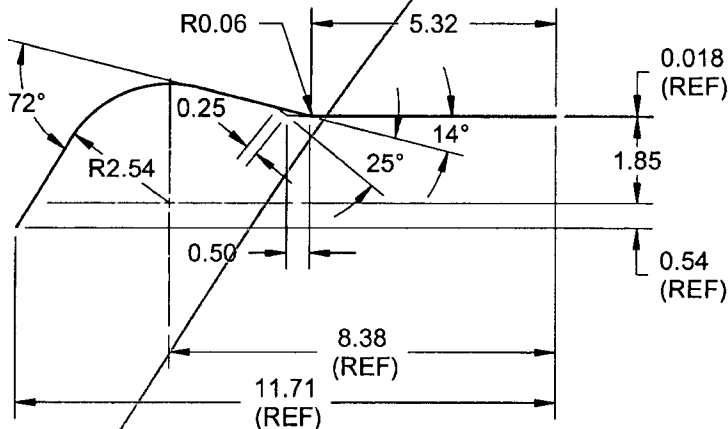
QTY -049	P/N	DESCRIPTION
	D3467-049	BAFFLE & DEFLECTOR ASSEMBLY
1	D3467-13	BAFFLE
2	D3467-15	DEFLECTOR

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DATE 06.05.15	TITLE SHROUD ASSEMBLY SCALE 1:4		

**D3467-1F COVER PLATE FLAT PATTERN****D3467-1 L/H COVER PLATE ISOMETRIC VIEW.
D3467-2 R/H COVER PLATE (OPPOSITE)**

SCALE 1:8

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NOTES:

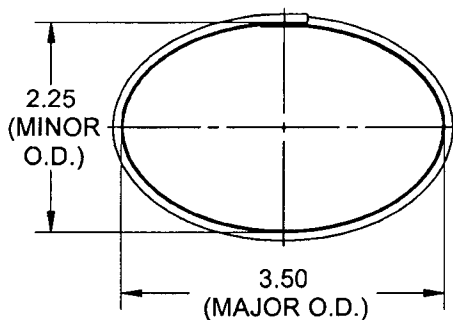
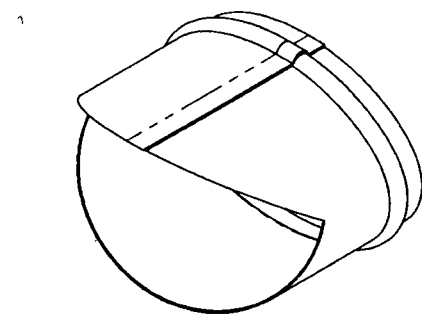
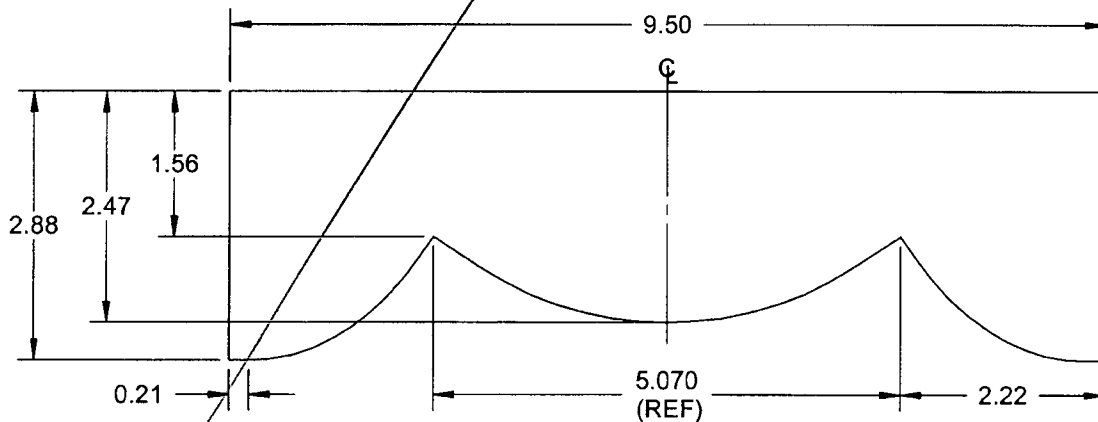
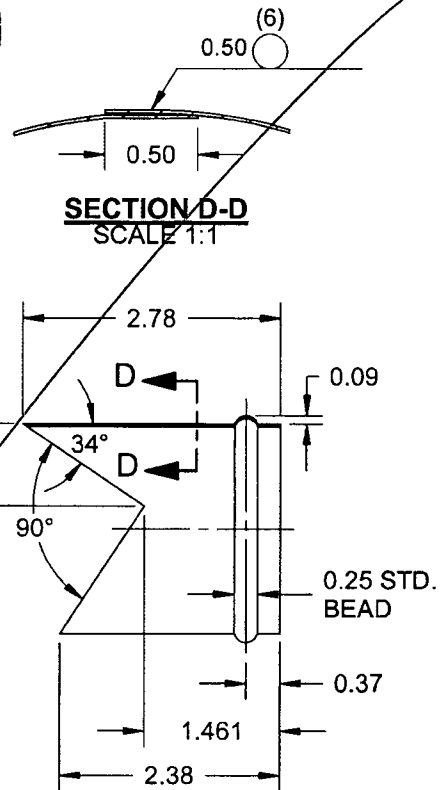
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

RELEASED
*[Stamp: 06.05.15]***UNDER REVIEW***[Stamp: 07.04.15]**Dial + planification
(Chamfer)***D3467-3 TUBE DETAIL****D3467-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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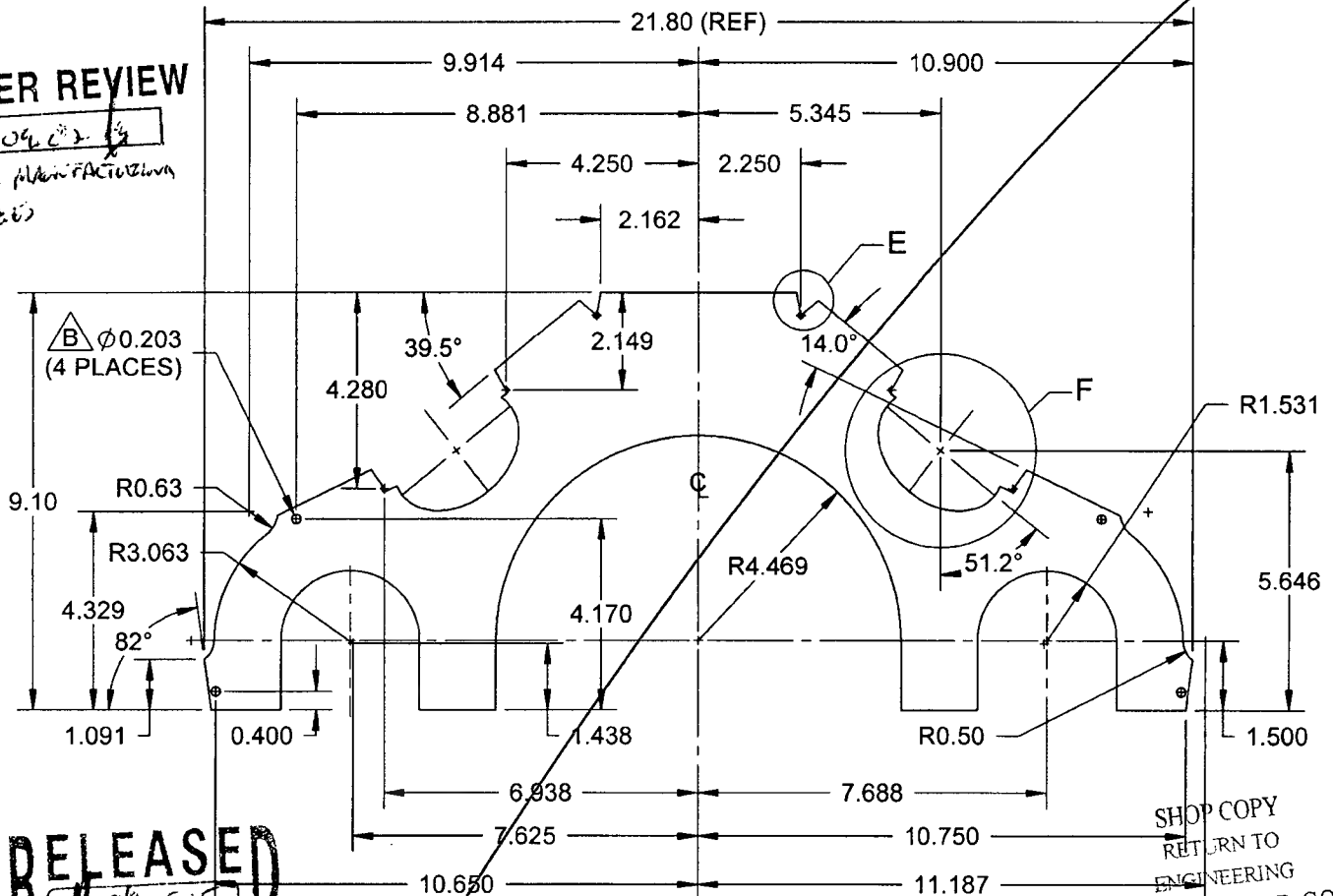
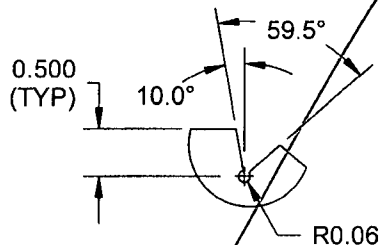
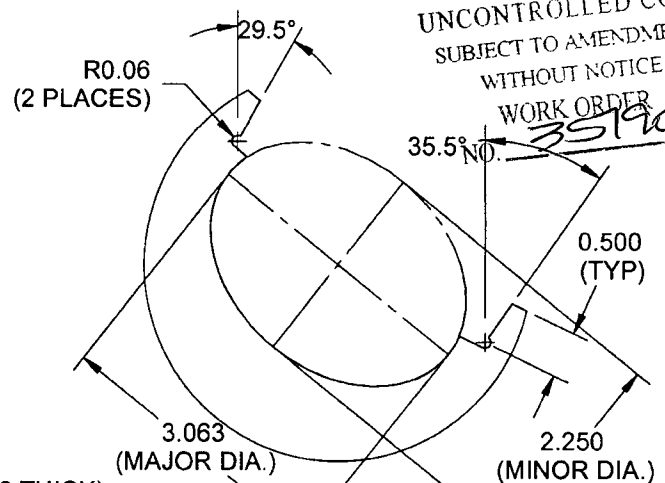
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:8

UNDER REVIEW

02.09.15
DIP + PLAN FACTORY
(VINT)

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WORK ORDER
35190**DETAIL E**
SCALE 1:2**DETAIL F**
SCALE 1:2**D3467-5F AFT PLATE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019
(ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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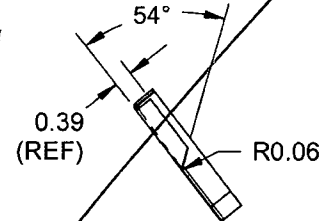
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. B SHEET 9 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

RELEASED
06.05.15

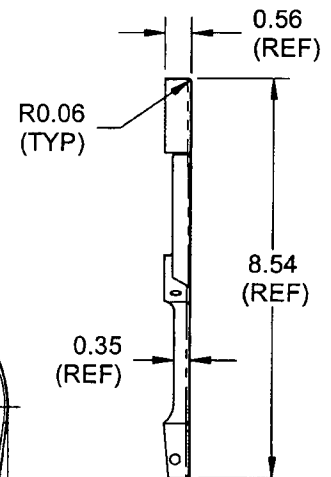
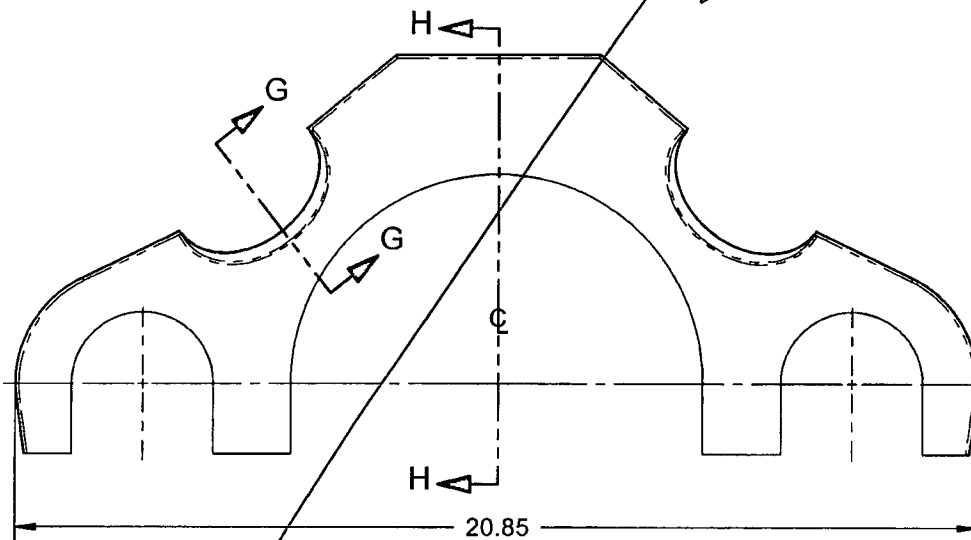
UNDER REVIEW

02.04.02

Dist + Manufacturing
(Chait)



SECTION G-G



SECTION H-H

D3467-5 AFT PLATE BENDING DETAIL

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

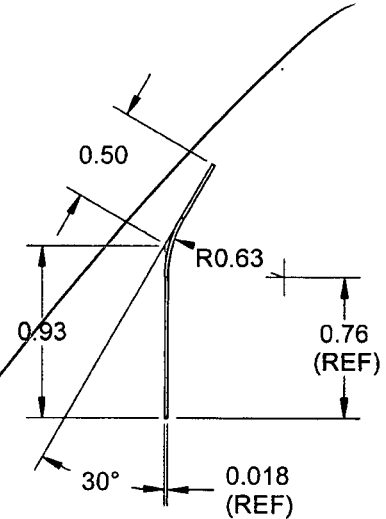
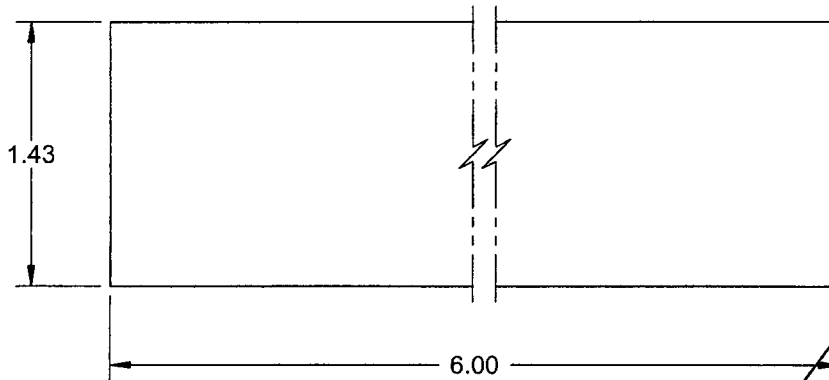
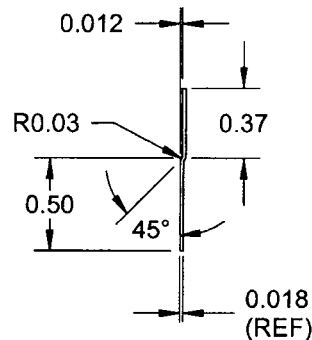
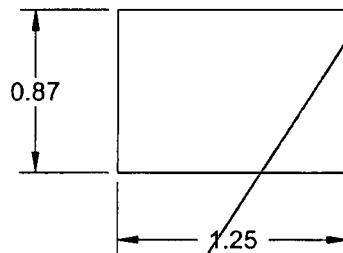
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:1

RELEASED
06.05.15**UNDER REVIEW***CA. 04.02.15*
Dim. & plan. FACTURING
*(V. 1.0)***D3467-7F SEAL STRIP**
FLAT PATTERN**D3467-7 SEAL STRIP**
BENDING DETAIL**D3467-11F BRACKET**
FLAT PATTERN**D3467-11 BRACKET**
JOGGLE DETAIL**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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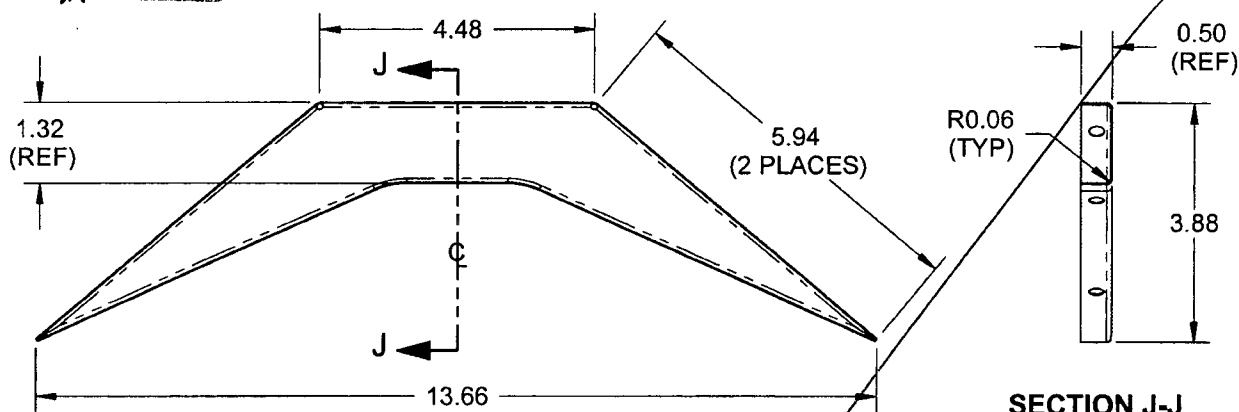
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:3

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[Signature] 06.05.15



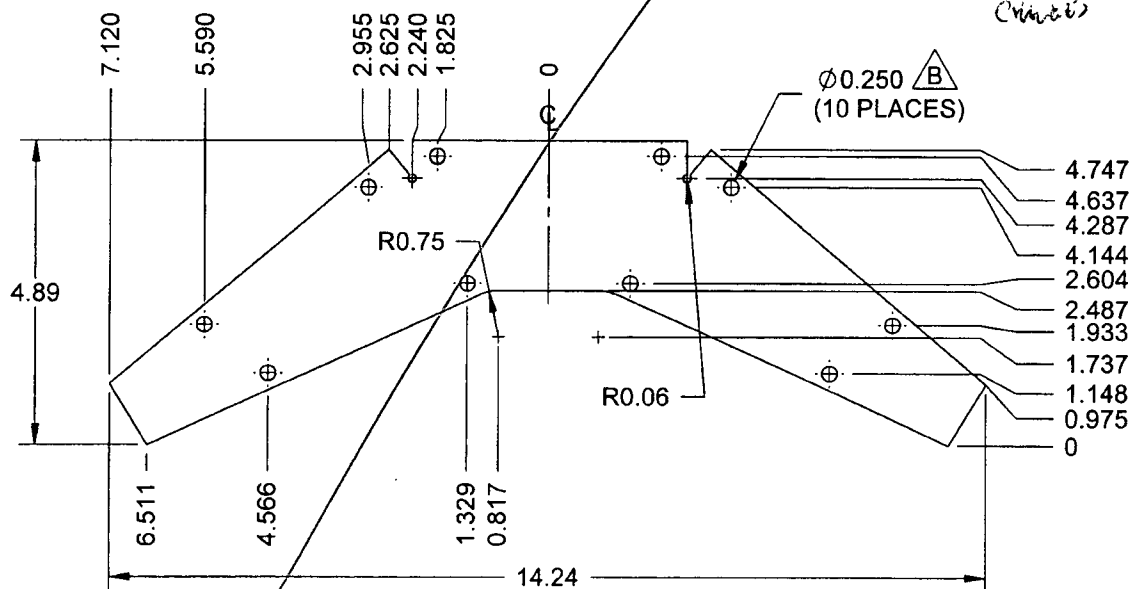
D3467-9 FWD PLATE BENDING DETAIL

SECTION J-J

UNDER REVIEW

[Signature]

*Dir + planification
Chate*



D3467-9F FWD PLATE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

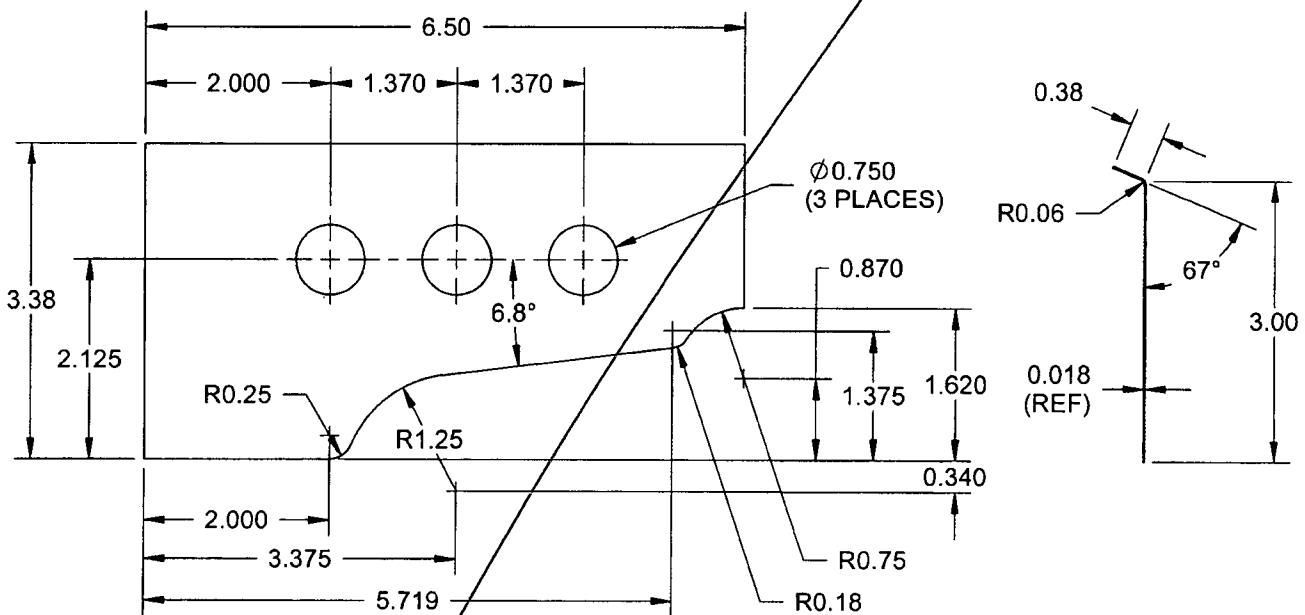
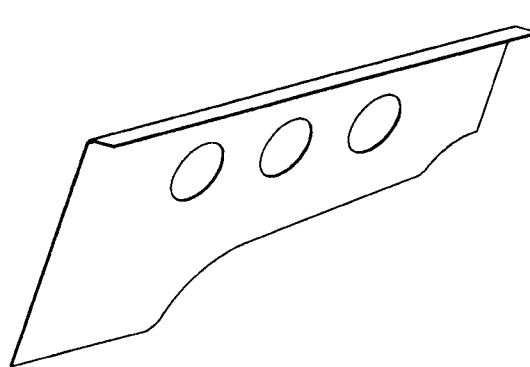
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*06.05.15***UNDER REVIEW***07.09.15**Dim + Manufacturing
Criteria***D3467-13F BAFFLE
FLAT PATTERN****D3467-13 BAFFLE
BEND DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

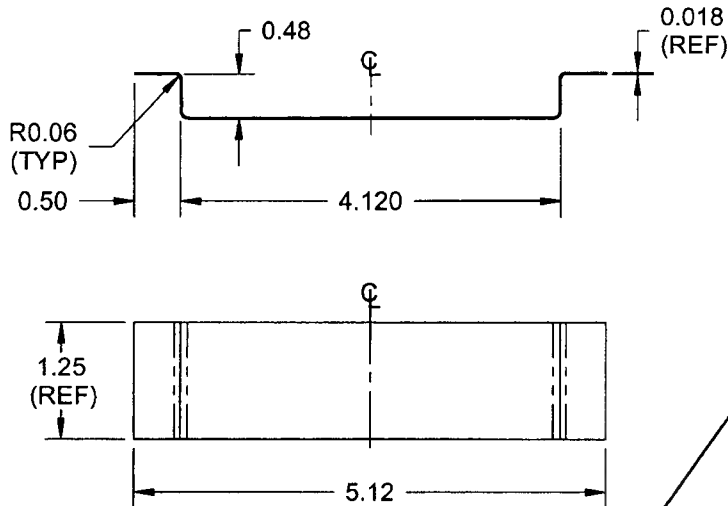
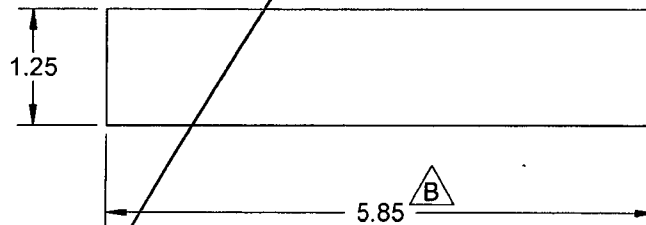
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

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*06-05-15***UNDER REVIEW**
07.09.15
Dim + Manufacturing
Changes**D3467-15 DEFLECTOR BENDING DETAIL****D3467-15F DEFLECTOR FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

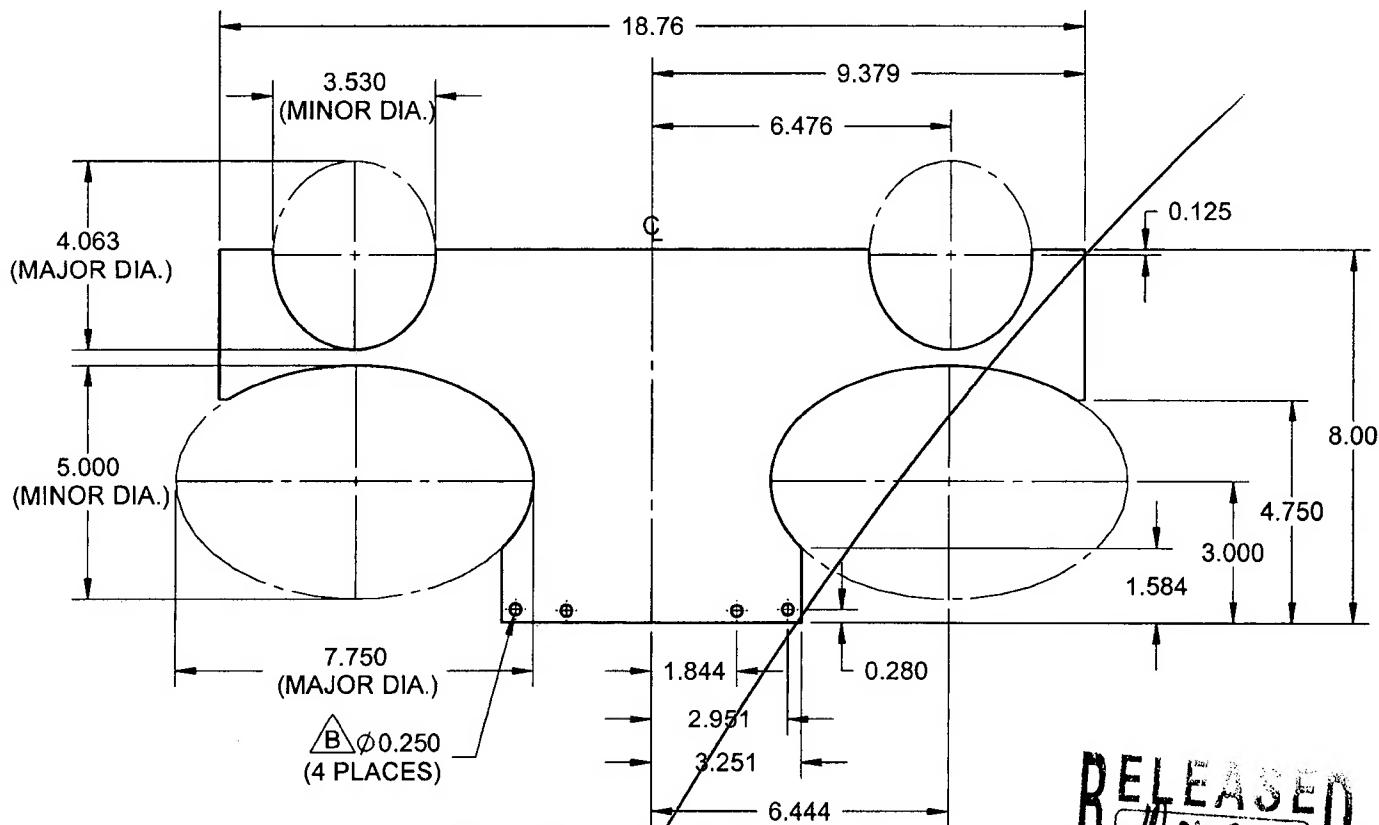
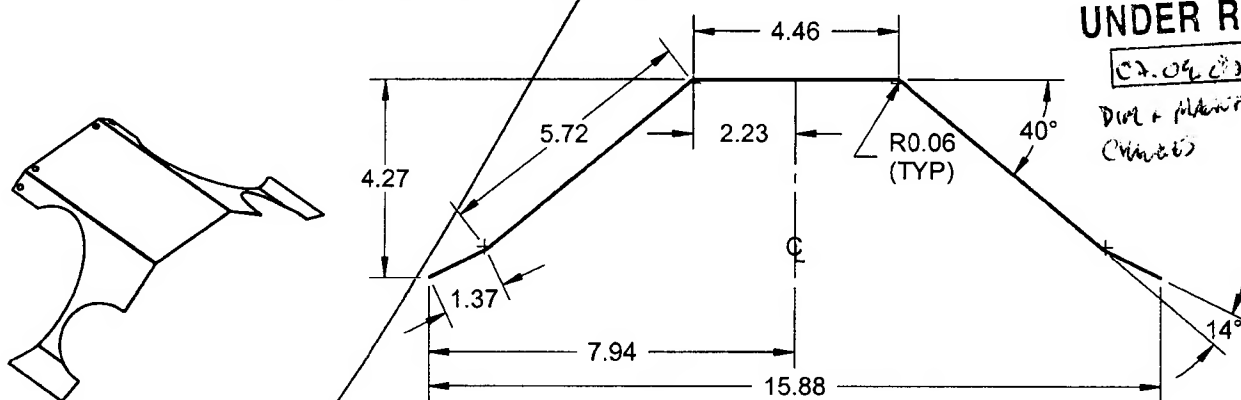
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

**D3467-17F TOP COVER FLAT PATTERN****D3467-17 TOP COVER BENDING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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#060515**UNDER REVIEW**07.09.02
Dirt + planification
(Chubb)

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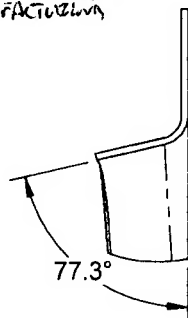
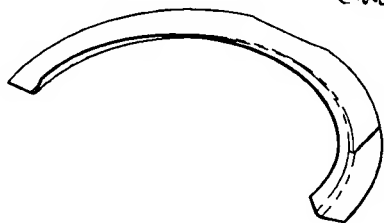
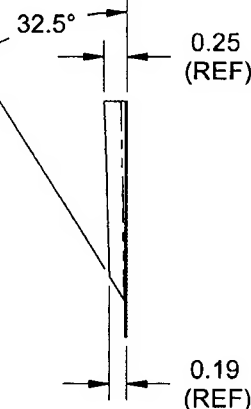
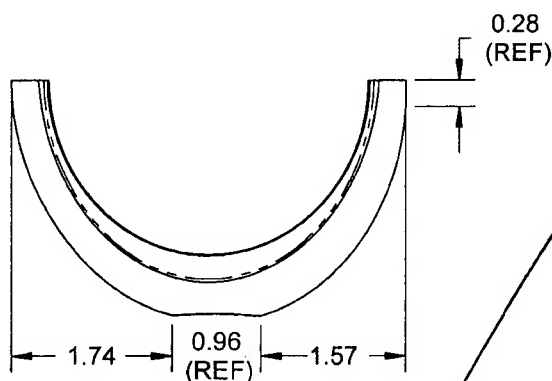
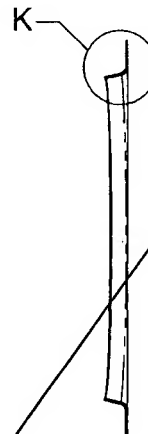
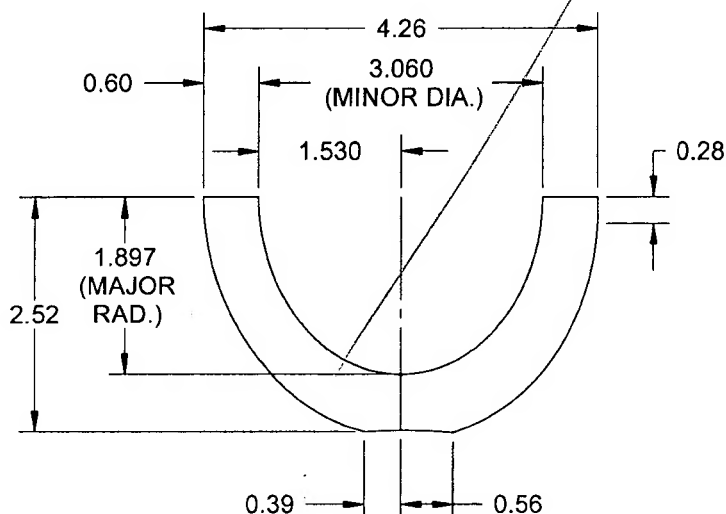
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*06.05.15***UNDER REVIEW***02.04.15**Dim + Manufacturing
Changes***DETAIL K**
SCALE 1:2**D3467-19 DOUBLER, L/H SHOWN**
D3467-20 DOUBLER, R/H OPPOSITE

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D3467-19F FLAT PATTERN**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 42

EMPLOYEE: Melanie Fauteux

PART NUMBER: D3467-049

JOB NUMBER: 835190

MATERIAL TYPE: 304L

MATERIAL THICKNESS: 0.16

GROUP SPECIFICATION

- ☐ Group 1: Aluminum & magnesium
☐ Group 2: Iron; nickel; cobalt
☒ Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[/]	[]
PENETRATION:	[/]	[]
PULL STRENGTH:	[/]	[]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/11/29
QUALIFIER: SB